

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000982**Date Inspected:** 25-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** No welding observed.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** 89 meter mock up**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) inspector, Scott Croff, was present at Zhenhua Port Machinery Company, Ltd (ZPMC) to observe the scheduled mock up construction and production construction of the SAS Superstructure.

At the beginning of the shift, the Quality Control Liaison (QCL) "Tom" Li Xiu Yang informed the QA inspector that ZPMC technicians have conducted ultrasonic testing (UT) on complete joint penetration (CJP) welds on the MUSB-MA22 A/B stiffener plate splices. (89 meter mock up, Skin D) The QA inspector was informed that welds #3, 4, 9, 10, 15 & 16 were inspected and accepted by ZPMC. The QA inspector was informed that verification could be conducted on these parts. Upon arrival to the shop floor, the QA inspector noted that ZPMC workers were preparing to heat straighten these parts. The QA inspector asked the QCL "Tom" why ZPMC has stated these welds were ready for verification when section 11 of the approved WQCP requires final NDE to be conducted after all heat straightening. The QA inspector was informed that there might have been misunderstandings in the status of the parts and their inspections. See the attached photo.

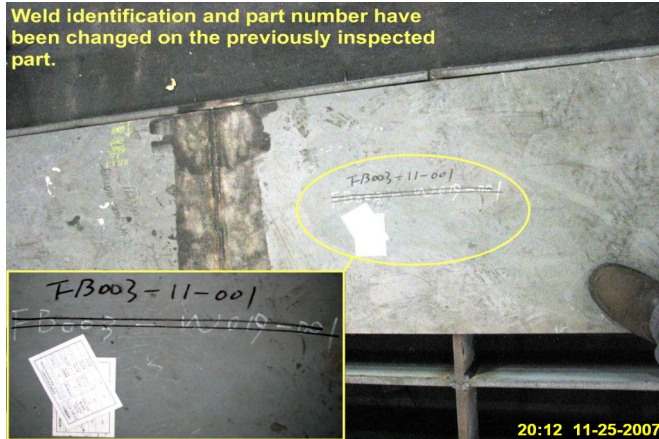
The QA inspector observed no welding on parts for this contract during this shift. The QA inspector noted that several Floor Beam segments that have been welded and previously inspected appear to have been re-labeled. The QA inspector observed the part numbers/ weld numbers and white tracking stickers have been changed. See the attached photo.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

As noted above, the QA inspector Scott Croff had discussions with the QCL "Tom". The QA inspector was notified of UT being accepted by ZPMC on the MUSB-MA22 A/B stiffener plate CJP splice welds. The general details of the conversation are described above. The QA inspector also asked the QCL "Tom" why there were misunderstandings about the status of parts and welds. The QCL replied that they will try to communicate better and the change of shifts might have had influence on the misunderstanding.

The QA inspector Scott Croff had general conversations with the QA inspector Roscoe Dixon. The QA inspectors discussed the above mentioned observations in regards that no welding was observed. There were no other notable conversations during this shift.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Croff, Scott	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar, Robert	QA Reviewer

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